

Work Order ID 75206
October-18-11 4:11:08 PM

Item ID: D3199-3

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

Required Date: 04/11/2011 Req'd Qty: 90.00

Reference:

Approvals:

Process Plan: M.L.S

QC:

Date: 11/10/18

Date:

Tooling:

SPC (Y/N):

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Nbr

Revision Nbr

D3199

E

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

Cut as per Dwg D3199

Dwg Rev: F

Prog Rev: F

Deburr if required

0.00

0.00

0.00

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

18/10-19

114

18/10-19

Work Order ID 75206

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Item ID: D3199-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Bracket, Fwd LH

Stop

NS2

Start Date: 18/10/2011 Start Qty: 90.00

90

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

90

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

Sul10/25

120

QC

Memo

0.00

Quality Control

COLLECT
414
as per

130

Bend as per dwg

0.00

S 11/10/26

130

Brake NC

Small Fab

Memo

0.00

Brake NC

(2)

140

QC5- Inspect part completeness to step on W/O

0.00

Sul10/27

140

QC

Memo

0.00

Quality Control

(+2)

3

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Item ID: D3199-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

90

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

90

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Packaging

Memo

0.00

2X ϕ m-f 11/10/27

2 COUNTED ϕ 11/10/27

11/10/27 S/P 20

Work Order ID 75206

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October-18-11 4:11:08 PM

Item ID: D3199-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

90

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

90

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

0.00

QC

Memo

Quality Control

11/10/27

Picklist Print

October-18-11 4:11:12 PM

Page 1

Work Order ID: 75206

Parent Item: D3199-3

Parent Item Name: Bracket, Fwd LH

75206

D3199-3

Start Date: 18/10/2011

Start Qty: 90.00

Required Date: 04/11/2011

Required Qty: 90.00

Comments:

IPP RevA: RevC-prelim DD verified by:EC
11,03.31 as per cen 11-531 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

137.0795

0.1673

15.84947

**

11-10-19

M304S20GA

304/316 .040 Sheet

Location

MAT020

Loc Qty

137.0795

Loc Code

116623

0.2

117550

8.363

117933

43.3442

118400

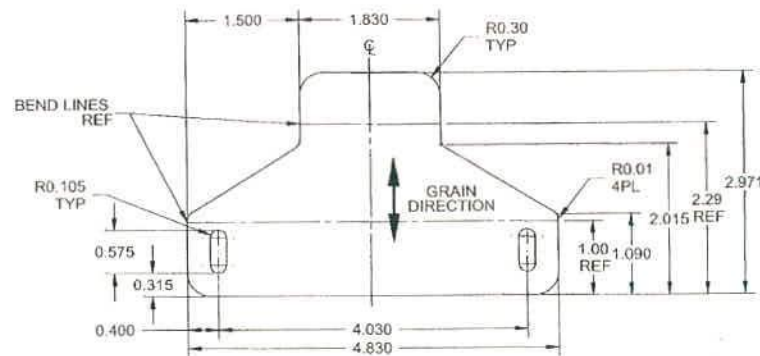
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118964

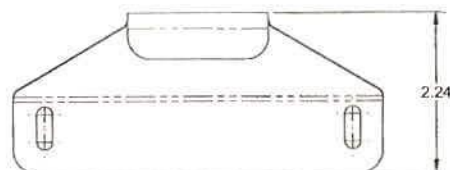
59.5

117933

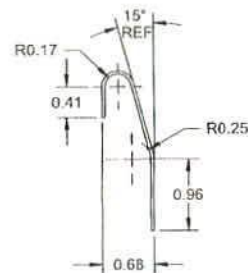
114



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F



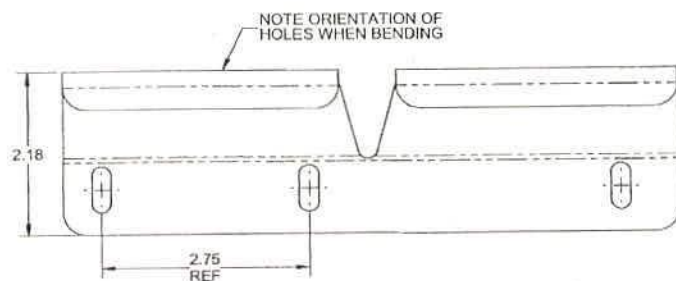
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

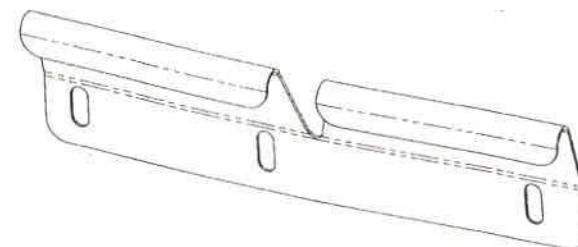
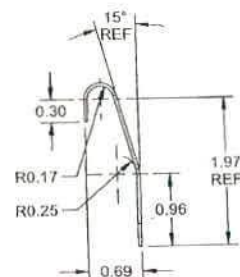
REV.	DESCRIPTION	BY	DATE
E	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PART 1-78	MB	11.03.21
C	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH, UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
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DRAWN			
CHECKED			
MFG. APPR.			
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DATE	11.07.11	REV. E	SHEET 1 OF 4
		SCALE	NTS

RELEASED
2011-07-18

75206



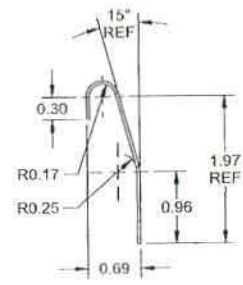
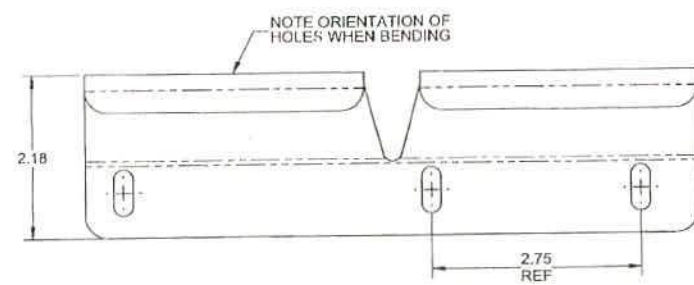
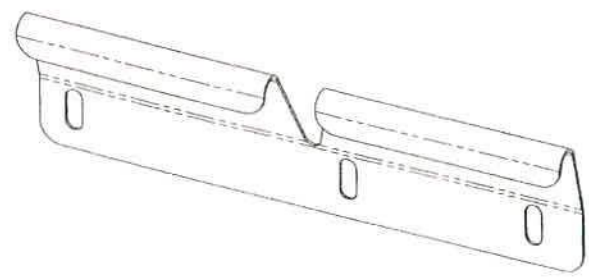
D3199-3 BRACKET
MADE FROM D3199-3F



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2011-07-18

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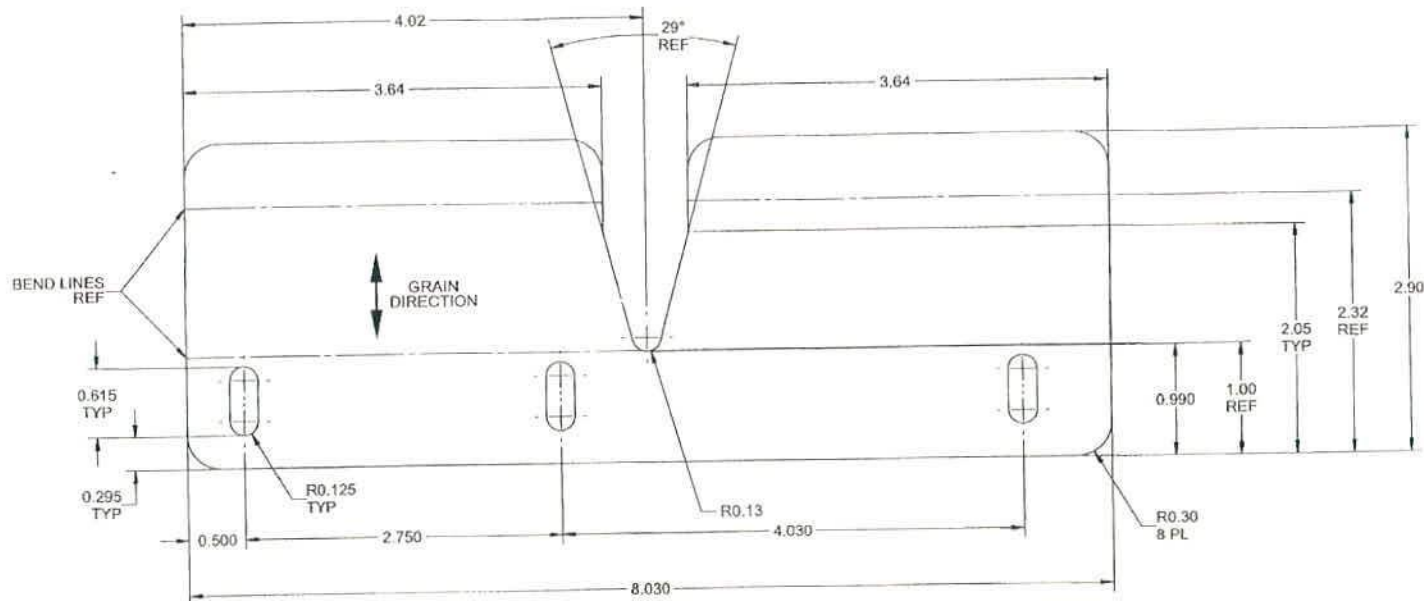


D3199-4 BRACKET
MADE FROM D3199-3F

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D3199-3F FLAT PATTERN

RELEASED
7011-07-18

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.25 lbs

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